

split

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35697 -2
Estimate Number : 12711
Order Number :
Date of Issue : 11/13/2007 S.O. No. :
Revised Rev. : NC
First Issue : 11 Type : SMALL /MED FAB
Previous Run : 33881

Drawing Name : WEARPAD

Part Number : D35373
Drawing Number : D3537 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 11/20/2007

Qty: 60 Um: Each

(55)

Written By :
Checked & Approved By :
Comment : Est Rev: A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



14.06.16



Comment: Qty.: 0.1512 sf(s)/Unit Total: 9.0720 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 105947 IB 07-11-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: C
Prog Rev: C

IB 07-11-15

(93)

2-Deburr if necessary IB 07-11-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary
Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3
Form Joggle as per Dwg D3537 on brake using Jig DT8158

07/11/16 (93)
07/11/17 (93)

Date: Tuesday, 11/13/2007 1:33:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35697

Part Number: D35373

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



QSP019



counters

Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

Alul.9

(X93)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

B106175 / B106390
M104709

(X54)

FL 8-9-17

8.0

QC10

VISUAL WELDING INSPECTION



counters

Comment: VISUAL WELDING INSPECTION

08/09/17

(X54)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/17

(X54)

10.0

POWDER COATING

POWDER COATING



M106442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 08-09-18

(X54)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/18

(54)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

FL 08/09/18

(54)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19

Job Completion

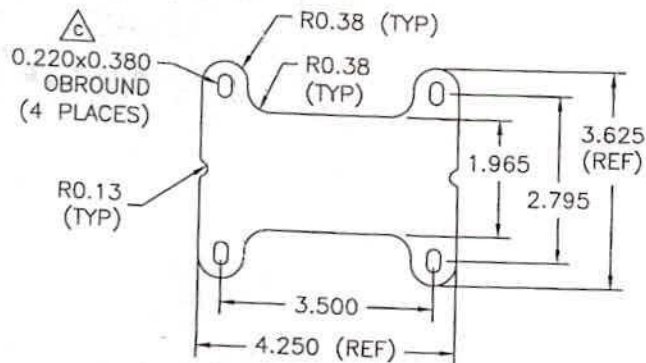


MF 08-09-19

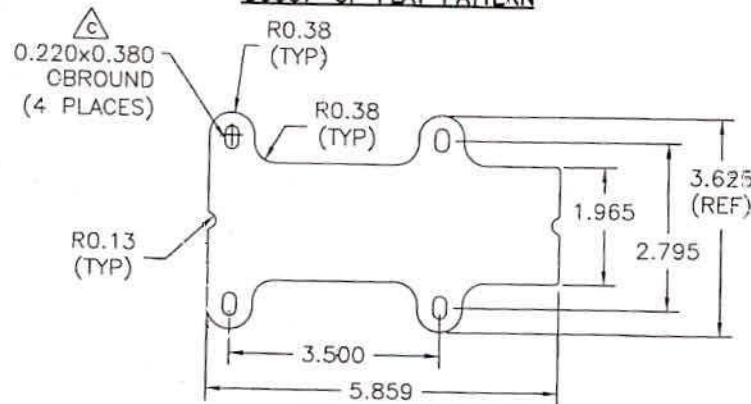




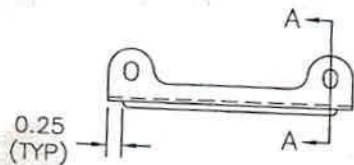
D3537-1F FLAT PATTERN



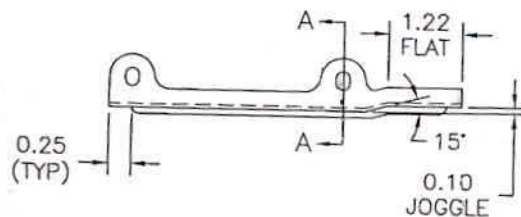
D3537-3F FLAT PATTERN



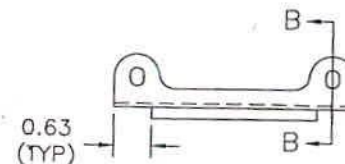
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



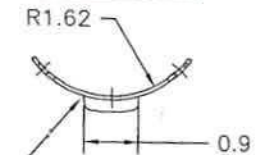
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

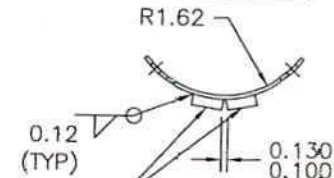


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

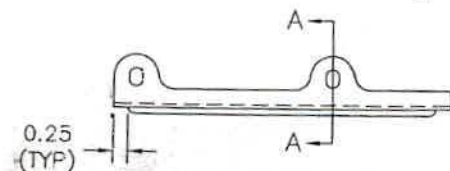
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-08 A6
PER ECU

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (43.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	
DRAWING NO.	D3537	
TITLE	WEARPAD	
REV. C		
SHEET 1 OF 1		
SCALE		
1:2		

WORK ORDER
35697
UNCONTROLLED COPY
RETURN TO
NOTICE

